

# Work Order ID 85798

June-15-12 11:56:20 AM

ASAP

\*85798\*

Page 1

Item ID: D3179-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Litter Tie Down

Start Date: 15/06/2012 Start Qty: 8.00 \*8\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 8.00 \*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/15 Tooling:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3179

Rev C

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.150" long

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: C 2-  
Deburr per dwg D3179-1

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FTO

and 12/06/19

FK 12/06/23

FK 12/06/23

12-06-20

NCR: ☒ Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA *[Signature]* Date: 12/06/28QA Closed: *[Signature]* Date: 12/8/9

Work Order: <u>B85798</u> Part No. <u>D3179-041</u> NCR No. <u>12-1537</u>				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>					
						Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	12-06-20	110	1	on program # 3000 for D3179-041 Folio is unclear as in where to locate the Y-axis origin	<i>[Signature]</i>	Scrap + replace <u>B 81421</u>	<i>[Signature]</i> 12-06-25	<i>[Signature]</i> 12/06/25	<i>[Signature]</i> 12-06-25
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

FAULT CATEGORY														
<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many			<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input checked="" type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input checked="" type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input checked="" type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing			<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material			<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

**Work Order ID 85798**

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**\*85798\***

Page 2

Item ID: D3179-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Litter Tie Down

Start Date: 15/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

OK 12/06/25

8

8

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

8 NG 12625

Hand Finishing

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

8 8 12626

Quality Control

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**\*85798\***

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Item ID: D3179-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Litter Tie Down

Start Date: 15/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

160

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

**\*160\***

*120 222*

*8 0 12-6-26*

Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:20* OVEN TEMPERATURE:  
*500* FINISH TIME: *10:50*

170

QC3- Inspect Part Finish

0.00

**\*170\***

*8x 12/06/26*

QC

Memo

0.00

Quality Control

180

Small Fab

0.00

**\*180\***

*8x 12/06/26*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3179

# Work Order ID 85798

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**\*85798\***

Page 4

Item ID: D3179-041  
Revision ID:  
Item Name: Fwd Litter Tie Down

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 15/06/2012 Start Qty: 8.00 **\*8\***  
Required Date: 22/06/2012 Req'd Qty: 8.00 **\*8\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		5710426		(xse)			

200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>225</u>  Memo	0.00 0.00							
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210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							
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(80) 216/2754

MCS 12/06/27

MCS 12/06/27

# Picklist Print

June-15-12 11:56:24 AM

Page 1

Work Order ID: 85798

\*85798\*

Parent Item: D3179-041

\*D3179-041\*

Parent Item Name: Fwd Litter Tie Down

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF  
IPP Rev:B Added Powder Coat 07-07-04 JLM  
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149D0332J Purchased No

100

Each

2,082.000

3

24

\*NAS1149D0332.J\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST297

1000

121708

1000

ST298

1082

105793

12

110985

4

117087

89

119042

16

119717

202

120644

7

121011

752

D2372

Manufactured

No

180

Each

18.0000

2

16

\*D2372\*

Quick Release

\*\*

Location

Loc Qty

Loc Code

ST

18

80274

2

80510

16

D2444

Manufactured

No

180

Each

13.0000

1

8

\*D2444\*

Pip Pin Assembly

\*\*

Location

Loc Qty

Loc Code

ST019

13

79477

13

# Picklist Print

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Work Order ID: 85798

**\*85798\***

Parent Item: D3179-041

**\*D3179-041\***

Parent Item Name: Fwd Litter Tie Down

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 8.00

Required Qty: 8.00

D6201      Manufactured      No      180      f      77.3800      1.0125      8.526316

**\*D6201\***

**\*\***

"T" Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	2.04	
57767	1.34	
71208	0.7	
MAT028	69	
81421	49	
83987	20	
MAT28	6.34	
77491	5.34	
81421	1	

8.53 on 12/06/19

MS21042L3      Purchased      No

180      Each      1,748.000      1      8

**\*MS21042L3\***

**\*\***

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1748	
115835	4	
117885	32	
119017	816	
119075	138	
121349	23	
121444	735	

EP 12/06/20

MS27039-1-13      Purchased      No

180      Each      109.0000      1      8

**\*MS27039-1-13\***

**\*\***

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	109	
110844	9	
119736	100	

EP 12/06/20

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Shop Packet Print

Page 2

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/>            Other <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering Quality <input type="checkbox"/>  <input type="checkbox"/>  <input type="checkbox"/>  <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other _____ _____ _____
---	--	---	--	--



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 05798
<b>Description:</b> Fwd Litter Tie Down Bracket		<b>Part Number:</b> D3179-1
<b>Inspection Dwg:</b> D3179 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00	✓		FK-04	Vern.
Ø0.242	+0.005/-0.001	.242	✓		"	"
R0.40	+/-0.030	.40	✓		rad gauge	
0.375	+/-0.010	.385	✓		FK-04	Vern.
Ø0.191	+0.005/-0.001	.191	✓		"	"
1.00	+/-0.030	1.00	✓		"	"
1.70	+/-0.030	1.697	✓		"	"
4.00	+/-0.030	4.002	✓		"	"
1.50	+/-0.030	1.502	✓		"	"
0.750	+/-0.010	.750	✓		"	"
1.50	+/-0.030	1.502	✓		"	"
10.500	+/-0.010	10.500	✓		CNC-01	Vern.
4.250	+/-0.010	4.250	✓		FK-04	Vern.
0.750	+/-0.010	.750	✓		"	"
1.000	+/-0.010	1.001	✓		"	"
12.00	+/-0.030	12.002	✓		CNC-01	Vern.
1.00	+/-0.030	1.001	✓		FK-04	Vern.
8.00	+/-0.030	8.00	✓		CNC-01	Vern.
Ø0.191	+0.005/-0.001	.191	✓		FK-04	Vern.
R0.37	+/-0.030	.37	✓		rad gauge	
0.97	+/-0.030	.966	✓		FK-04	Vern.
1.86	+/-0.030	1.866	✓		"	"
1.750	+/-0.010	1.750	✓		"	"
0.375	+/-0.010	.380	✓		"	"
2.875	+/-0.010	2.875	✓		"	"
0.500	+/-0.010	.500	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
1.625	+/-0.010	1.625	✓		"	"
3.31	+/-0.030	3.31	✓		"	"

<b>Measured by:</b> FK-	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/06/23	<b>Date:</b> 12/06/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	P/O D3179-041	KJ/DD [Signature]

MS27039-1-13 SCREW  
NAS1149D0332J WASHER, 3 PL  
MS21042L3 NUT

D2444  
PIP PIN

D3179-1 LITTER TIE  
DOWN BRACKET

D2372 QUICK  
RELEASE  
2 PL

 **D3179-041 FWD LITTER TIE DOWN BRACKET**




**NOTES:**

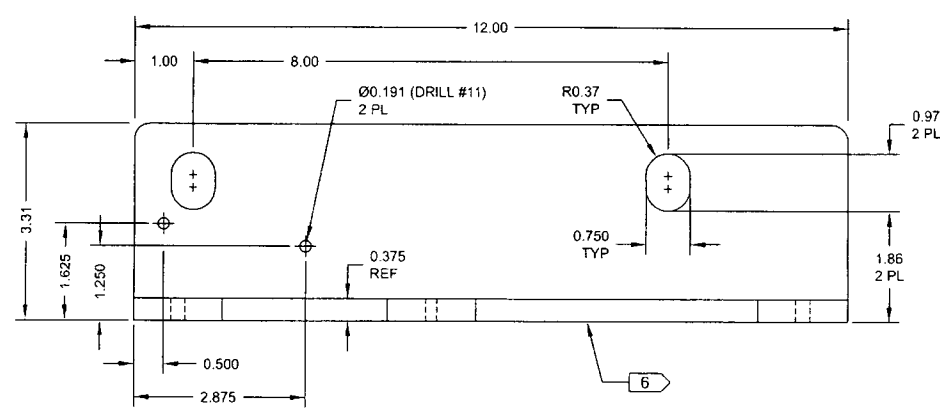
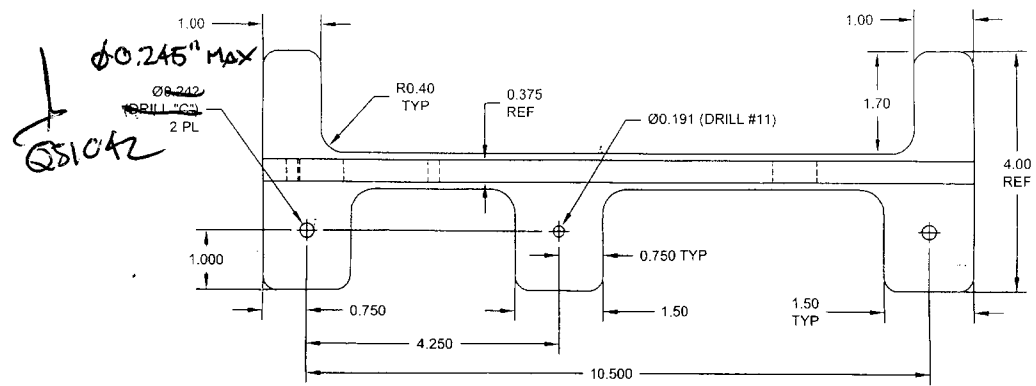
1) D3179-041 WEIGHT: 2.79 lbs

Item	Qty	Part Number	Description
	-041		
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85798 MLJ  
12/06/15

**RELEASED**  
08/11/21

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# **D3179-1 LITTER TIE DOWN BRACKET**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY DESIGNED AND MANUFACTURED.	

05798

RELEASED  
08/11/07

